

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021906**Date Inspected:** 29-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

WELDING

This QA Inspector observed the following work in progress:

BAY 14

This QA Inspector observed ZPMC qualified welding personnel identified as 067942 perform repair welding by Shielded Metal Arc Welding (SMAW), on vertical shear plate to bottom plate of OBG Segment 14W. Weld joint is identified as SEG3020BB-019. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair and Critical welding repair report B-CWR2752.

This QA Inspector observed ZPMC qualified welding personnel identified as 066734 perform welding by Flux Cored Arc Welding (FCAW), on Deck panel diaphragm to Floor beam flange weld of OBG Segment 13CW. Weld joint is identified as SEG3015H-002. ZPMC Quality Control (QC) Inspector identified as Qiu Wen was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 037840 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel of OBG Segment 14W. Weld joint is identified as DP3133-001-019.

WELDING INSPECTION REPORT

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ABF Quality Control (QC) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 037932 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel of OBG Segment 14W. Weld joint is identified as DP3133-001-020. ABF Quality Control (QC) Inspector identified as Shen Jian was present to monitor the welding process. The welding variables recorded by ABF QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067609 perform repair welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Side plate weld of OBG Segment 14W. Weld joint is identified as SEG3020AL-005. ZPMC Quality Control (QC) Inspector identified as Qiu Wen was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345 SMAW-4G (4F)-FCM-Repair and welding repair report B-WR18585.

This QA Inspector observed ZPMC qualified welding personnel identified as 066361 perform welding by Shielded Metal Arc Welding (SMAW), on Floor beam to Side plate stiffener weld of OBG Segment 13AW. Weld joint is identified as SEG3013P-207. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067876 perform welding by Flux Cored Arc Welding (FCAW), on Floor beam to Side plate stiffener weld of OBG Segment 13AW. Weld joint is identified as SEG3013P-149. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-T-2233-ESAB.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye, Anand	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
